

Date: Friday, 13/06/2008 1:48:45 PM  
 User: Julie Lecocq

## Process Sheet

|                       |                                                                                                                                                                                                                    |                  |               |
|-----------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                                                                                                                                                                              | Drawing Name     | : WINDOW      |
| Job Number            | : 39873                                                                                                                                                                                                            |                  |               |
| Estimate Number       | : 11176                                                                                                                                                                                                            |                  |               |
| P.O. Number           | :                                                                                                                                                                                                                  | Part Number      | : D32903      |
| This Issue            | : 13/06/2008 S.O. No. :                                                                                                                                                                                            | Drawing Number   | : D3290 REV C |
| Prsht Rev.            | : NC                                                                                                                                                                                                               | Project Number   | : N/A         |
| First Issue           | : // Type : THERMOFORMING                                                                                                                                                                                          | Drawing Revision | : C           |
| Previous Run          | : 35975                                                                                                                                                                                                            | Material         | :             |
| Written By            | :                                                                                                                                                                                                                  | Due Date         | : 23/06/2008  |
| Checked & Approved By | : <u>JLD 08.0.13</u>                                                                                                                                                                                               | Qty:             | 12 Um: Each   |
| Comment               | : Est. A 04.08.18 New issue KJ/RF<br>: Est. B 06.05.09 Ecn 798 EC<br>: Est. C 07.05.29 Thermoform in-house DL<br>: Est. D 07.09.28 rev C dwg EC verified by: DD<br>: Est. E 07.11.28 Add -Hand finish deburring DL |                  |               |

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLCS125 MLE x 5125 903401 1/8" Polycast II Sheet



64



Comment: Qty.: 3.1500 sf(s)/Unit Total: 37.8000 sf(s)  
 Polycast II or plexiglass G .125"

~~107252~~

B

8-6

20

108344

107252

PTO

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3290  
 Dwg Rev: C  
 Prog Rev: C

B 8-6

20

(18)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-6

20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



S 08/06/20 x 16



Comment: SECOND CHECK

08/06/17 (18)

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3290-3 PAR #:            Fault Category: Pullers ass <sup>med & small</sup> water jet. NCR: Yes No DQA: D Date: 08/07/08  
D350-567. QA: N/C Closed: D Date: 08/07/08

| NCR: 39873 |      | WORK ORDER NON-CONFORMANCE (NCR)                                                                                   |                             |                                                               |                           |                             |                       |                             |
|------------|------|--------------------------------------------------------------------------------------------------------------------|-----------------------------|---------------------------------------------------------------|---------------------------|-----------------------------|-----------------------|-----------------------------|
| DATE       | STEP | Description of NC<br>Section A                                                                                     | Corrective Action Section B |                                                               |                           | Verification<br>Section C   | Approval<br>Chief Eng | Approval<br>QC Inspector    |
|            |      |                                                                                                                    | Initial<br>Chief Eng        | Action Description<br>Chief Eng                               | Sign &<br>Date            |                             |                       |                             |
| 08/06/17   | 2.0  | During inspection it was found that the operator <del>scrap</del> pulled M&E + ANS. 125" instead of MACRYLIC. 125" | <i>[Signature]</i>          | Retrain operator that he can not AND ACRYLIC are not the same | <i>[Signature]</i> 8-6-20 | <i>[Signature]</i> 08/06/20 | <i>[Signature]</i>    | <i>[Signature]</i> 08/06/17 |
|            |      | R.L. operator error. operator thought it was the same.                                                             | <i>[Signature]</i>          | SCRAP all P2 learn windows. AND replace with correct mat.     | <i>[Signature]</i> 8-6-20 | <i>[Signature]</i> 08/06/20 | <i>[Signature]</i>    | <i>[Signature]</i> 08/06/17 |
|            |      |                                                                                                                    |                             | MACRYLIC 125" B2 108344 7-18 16725                            |                           |                             |                       |                             |
|            |      |                                                                                                                    |                             |                                                               |                           |                             |                       |                             |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 39873

Part Number: D32903

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Without removing protective skin  
remove sharp edge by degurring.

x18

08.06.24 WH

6.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. D 3290

Folio Rev A

x18

08.06.24 WH

2-Engrave part# & batch#,  
(D3290-3)

08/06/25 BB x18

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances

08.06.24 WH

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/06/25 x18

9.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

BB 08/06/25 x18

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/06/25 x18

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

08/7/03 (1)  
SAP 08/07/03 (18)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Drawing Name: WINDOW

Job Number: 39873

Part Number: D32903

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

FWD  
INBOARD

D2126-0780 LOCKING SEAL  
(TRIM TO FIT)  
D3290-1 WINDOW FRAME  
D3290-3 WINDOW

1.10 (TYP)  
DIST. FROM FRAME  
EDGE TO WINDOW

D2126-0780 LOCKING SEAL  
(REF)

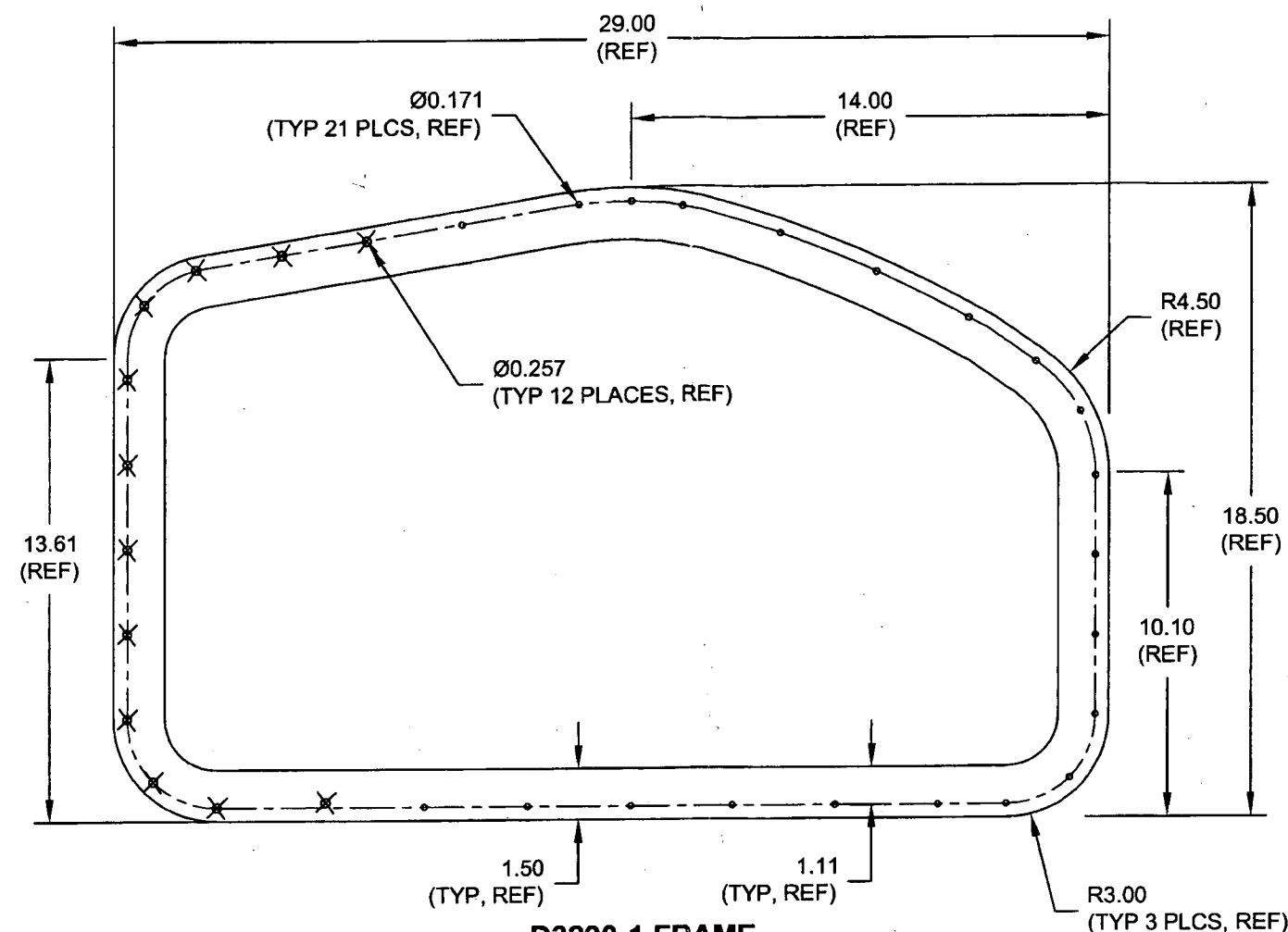
ENSURE D3290-3 WINDOW IS INSTALLED  
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

SECTION A-A  
NTS

### D3290-041 REPLACEMENT WINDOW ASSEMBLY

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

**GENERAL NOTES:**  
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED



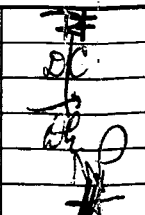
### D3290-1 FRAME

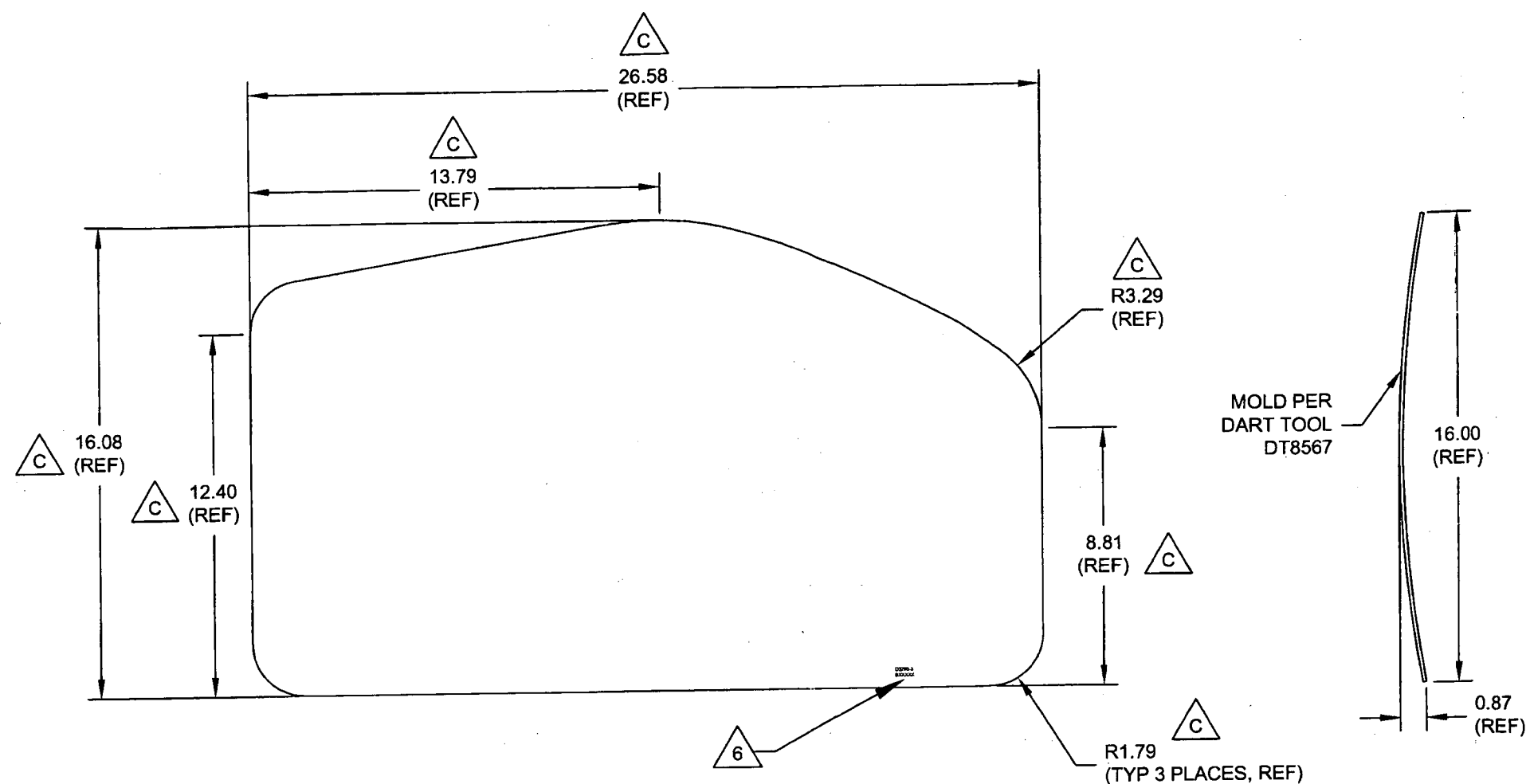
#### D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED  
07.09.22

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WITHOUT NOTICE  
WORK ORDER  
NO. 39275

|            |                                                                                                                                                                                                                               |                                                          |              |
|------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|--------------|
| C          | UPDATE DIMS PER PAR 188                                                                                                                                                                                                       | DC                                                       | 07.07.24     |
| B          | UPDATE MATERIAL PER NCR 029                                                                                                                                                                                                   | MB                                                       | 06.04.20     |
| A          | NEW ISSUE                                                                                                                                                                                                                     | RF                                                       | 04.06.14     |
| REV.       | DESCRIPTION                                                                                                                                                                                                                   | BY                                                       | DATE         |
| DESIGN     |                                                                                                                                          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |              |
| DRAWN      |                                                                                                                                                                                                                               |                                                          |              |
| CHECKED    |                                                                                                                                                                                                                               | DRAWING NO.                                              | REV. C       |
| MFG. APPR. |                                                                                                                                                                                                                               | D3290                                                    | SHEET 1 OF 2 |
| APPROVED   |                                                                                                                                                                                                                               | TITLE                                                    | SCALE        |
| DE APPR.   | REPLACEMENT WINDOW ASSEMBLY                                                                                                                                                                                                   | 1:                                                       |              |
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### D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) REMOVE SHARP EDGES
  - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
  - 7) WEIGHT: 1.87 +/- 0.42 LBS
  - 8) MOLD PER DART TOOL DT8567

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WITHOUT NOTICE  
WORK ORDER  
NO. 39813

**RELEASED**  
07.09.22 #

|            |              |                                                                                                                                                                                                                                                                                         |              |
|------------|--------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | <u>39813</u> | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                               |              |
| DRAWN      | <u>DF</u>    | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                             |              |
| CHECKED    | <u>DF</u>    | DRAWING NO.                                                                                                                                                                                                                                                                             | REV. C       |
| MFG. APPR. | <u>DF</u>    | D3290                                                                                                                                                                                                                                                                                   | SHEET 2 OF 2 |
| APPROVED   | <u>DF</u>    | TITLE                                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   | <u>DF</u>    | REPLACEMENT WINDOW ASSEMBLY                                                                                                                                                                                                                                                             | 1:5          |
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